



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-3

Job Sheet 167178



Part No: D3319-3

Job Qty: 16 ea

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/25/17

Job Tracking No:

Due Date: 11/3/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Hydro One Networks Inc (CHYDR01)

Lake Simcoe Regional Airport RR #2, 224 Line 7, North Oro Station, ON, L0L 2E0 Canada ph:(705) 487-1771

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	16 Ea		11/2/17	0.00	0.00	Start Up Small Fab2	SC
100	Waterjet	16 pcs		11/2/17	0.00	3.74	Waterjet1	SC
110	QC	16 pcs		11/2/17	0.00	0.00	QC2	SC
120	QC	16 pcs		11/2/17	0.00	0.00	QC8	SC
140	Brake NC	16 pcs		11/2/17	0.12	1.12	Brake NC 1	SC
150	QC	16 pcs		11/2/17	0.00	0.00	QC5	17-12-14/24
160	Autoweld 1	16 pcs		11/2/17	0.00	5.10	Automated welding	PD 17-12-13
170	QC	16 pcs		11/2/17	0.00	0.00	QC10	PD 17-12-13
180	QC	16 pcs		11/2/17	0.00	0.00	QC5	PD 17-12-13
190	HandFinish	16 pcs		11/3/17	0.00	0.56	Spray Paint	AB DEC 17 2017
200	QC	16 pcs		11/3/17	0.00	0.00	QC3	17-12-19/24
210	Packaging	16 pcs		11/3/17	0.00	0.00	Packaging3	
220	QC21-SA	16 Ea		11/3/17	0.00	0.00	QC21	

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319

160 - 8259 Hardcoat Rod 138629

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 138637

210 - Identify on inside surface using a permanent fine point marker with the following:

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S18GA	52	131	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Line ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Part ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermal ☐	Rec/Store/Packaging ☐	Supplier ☐	Other ☐

Date : _____

Job No: 167178
Mfg Date: 11/30/17

Start up Operation
D3319-3

Change No:
Operation:
Revision:
PART NO:



MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause		Positioned Wrong	
Environment ☐	No Ri ☐	Loss/Surge ☐	Outside Dimensions ☐
Design ☐	Operz ☐	Folio/Program ☐	Over/Under tolerance ☐
Doc/Data ☐	Offset ☐	Grain ☐	Part Incorrect ☐
Equip/Tooling ☐	Supplie ☐	Weld ☐	Part Lost/Missing ☐
Handling/Pre ☐	Training ☐	Wrong Stock Pulled ☐	Part Moved ☐
Material ☐	Use for Testing ☐	Out of Sequence ☐	Drawing ☐
Internal Transport ☐	Poor Information ☐	Off-set ☐	Finish ☐
Tribal Knowledge ☐	Rushing ☐	Mislabeled ☐	Misread ☐
LOA ☐	Product Improvement ☐	Fit/Function ☐	Turning Sequence ☐
Substation ☐	Process Improvement ☐	Misaligned/off center ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
OTHER : _____			

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

4	Wearplate	0.607inches ± 0.010	0.617 0.597
5	Wearplate	2.940inches ± 0.030	2.970 2.910
6	Wearplate	2.690inches ± 0.030	2.720 2.660
7	Wearplate	3.527inches ± 0.010	3.537 3.517
8	Wearplate	4.520inches ± 0.030	4.550 4.490
9	Wearplate	5.063inches ± 0.010	5.073 5.053
10	Wearplate	6.160inches ± 0.030	6.190 6.130
11	Wearplate	0.600inches ± 0.030	0.630 0.570
12	Wearplate	8.690inches ± 0.010	8.700 8.680
13	Wearplate	30.790inches ± 0.010	30.800 30.780
14	Wearplate	52.880inches ± 0.030	52.910 52.850
15	Wearplate	62.770inches ± 0.010	62.780 62.760
16	Wearplate	74.420inches ± 0.010	74.430 74.410
17	Wearplate	75.520inches ± 0.030	75.550 75.490
18	Wearplate	0.050inches ± 0.010	0.060 0.040

Plex 10/25/17 2:37 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order:	167178
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	Ø0.191	1		VRC-Ø	
Ø0.500	+0.006/-0.001	Ø0.501	1			
0.316	+/-0.010	0.318	1			
0.607	+/-0.010	0.609	1			
2.94	+/-0.030	2.954	1			
2.69	+/-0.030	2.702	1			
3.527	+/-0.010	3.529	1			
4.52	+/-0.030	4.534	1			
5.063	+/-0.010	5.064	1			
6.16	+/-0.030	6.178	1			
0.60	+/-0.030	0.617	1			
8.690	+/-0.010	8.691	1			
30.790	+/-0.010	30.791	1			
52.88	+/-0.030	52.898	1			
62.770	+/-0.010	62.771	1			
74.420	+/-0.010	74.421	1			
75.52	+/-0.030	75.532	1			
0.050	+/-0.010	0.048	1			

Measured by:	SC	Audited by:	43	Preliminary Approval:	
Date:	17/11/30	Date:	NOV 01 2012	Date:	

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	